



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2282-3

Job Sheet 172487



Part No: D2282-3

Job Qty: 40 ea

Part Name: Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/20/18

Job Tracking No:

Due Date: 3/2/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea		3/1/18	0.00	0.00	Start Up Machining	71916	JB 18-03-01
100	Hardinge	40 pcs		3/2/18	0.01	1.26	Hardinge	11	J.B 18-03-01
120	QC	40 pcs		3/2/18	0.00	0.00	QC8		JB 18/03/05
130	Packaging	40 pcs		3/2/18	0.00	0.00	Packaging3		EL
140	QC21-SA	40 Ea		3/2/18	0.00	0.00	QC21		

Part Op 100 - 1-Turn as per Dwg D2282 and Folio FA188

Descriptions: 130 - *****STOCK IN LARGE FAB***** LOCATION : WA002

DAS
21
9-82

MAR 05 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304P0.675W.091	304/316 Pipe .675 OD x .091 Wall Thickness	7.9160 ft (.1979 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304P0.675W.091	8	31	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Handle Tube	2.375Inches	+ 0.000 - 0.020	2.375 2.355	

Plex 2/20/18 8:54 AM Dart.lajeunesse.marie



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Container No: S047034

Part: D2282-3

Job No: 172487

Serial No/Batch: S047034

Revision:

Inspector:

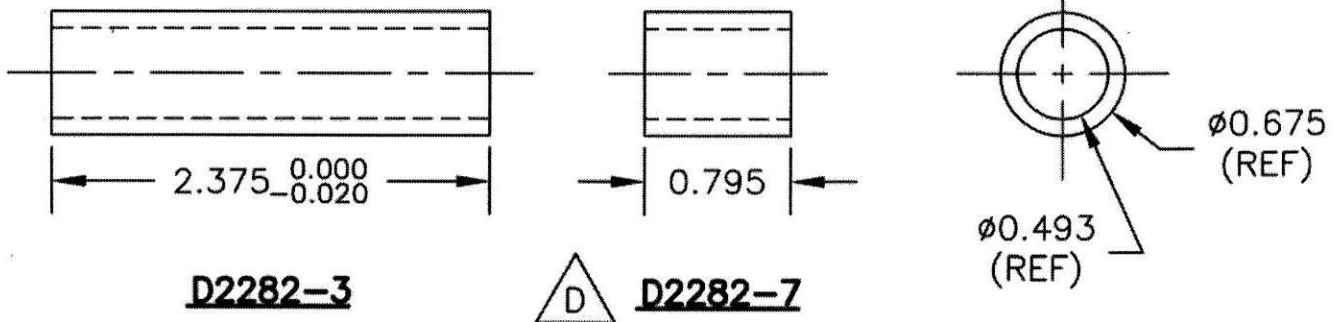
Date: 03/01/18



DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

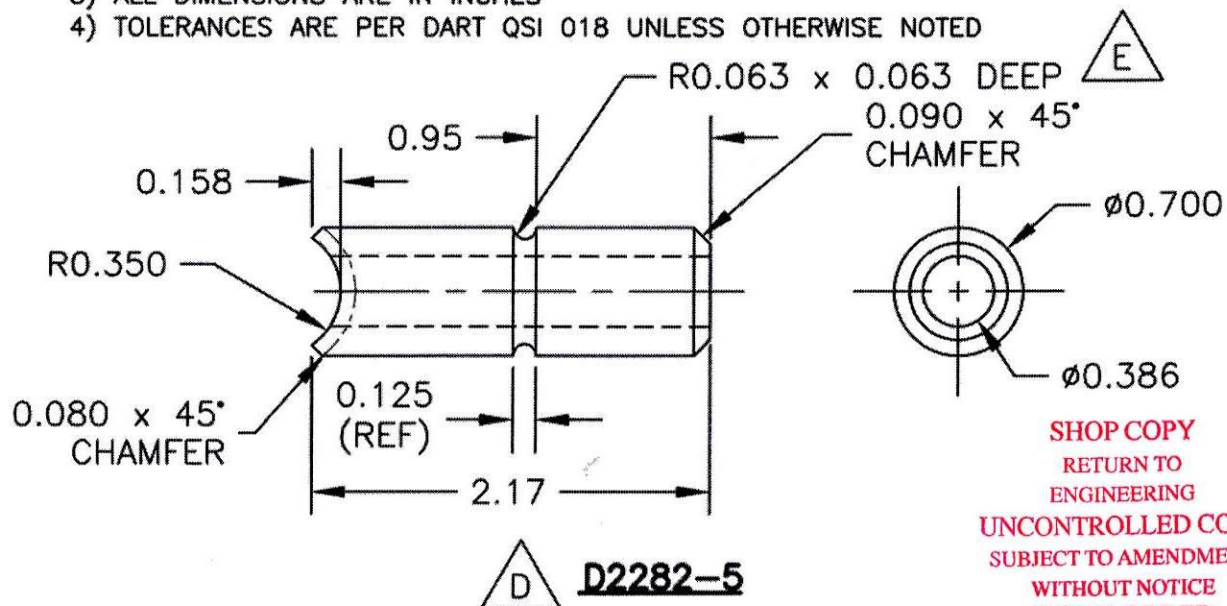
RELEASED
[Signature]
05/09/16

DEO ATTACHED



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
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WITHOUT NOTICE
WORK ORDER

NO. 172481 *[Signature]*

FEB 20 2018

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DRAWING NO. D2282	TITLE HANDLE TUBES	REV. E	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2282-E-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>M Lee</i>	MFG. APPR. <i>DD</i>	APPROVED <i>all</i>		DE APPR. <i>N/A on</i>		
DATE 17.02.24	DATE 17.06.22	DATE 17-6-22	DATE 2017.06.23		DATE <i>N/A on</i>		

PURPOSE

CORRECT MATERIAL CALL-OUT TO ELIMINATE PIPE/TUBE CONFUSION (NCR16-5830)

CHANGE

MATERIAL CALL-OUT FOR D2282-3/-7 ON SHEET 1 IS UPDATED AS FOLLOWS:

IS:

D2282-3/-7 TUBE:

- 1) MATERIAL: Ø0.675 X 0.091 WALL SEAMLESS ROUND TUBING, TP304/TP316 STAINLESS STEEL PER ASTM A213 / A269 OR ASME SA213 / SA269
(REF. DART SPEC. M304TR0.675W0.091)
OR
3/8 SCHEDULE 40 SEAMLESS PIPE, TP304/TP316 STAINLESS STEEL PER ASTM A312 OR ASME SA312
(REF. DART SPEC. M304P0.675W0.091)

WAS:

D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W0.091)

RELEASED

2017 JUN 26 *q*
ECN 17-595